

Date: Friday, 8/3/2007 9:25:53 AM  
 User: Jean-Luc Menard

## Process Sheet

|   |                                       |
|---|---------------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services        | Drawing Name : TUBE                   |
| Job Number : 33829                                    |                                       |
| Estimate Number : 11168                               |                                       |
| P.O. Number : N/A                                     | Part Number : D22823                  |
| This Issue : 8/3/2007 S.O. No. : N/A                  | Drawing Number : D2282 REV E          |
| Prsht Rev. : NC                                       | Project Number : N/A                  |
| First Issue : 8/3/2007 Type MACHINED PARTS            | Drawing Revision : E                  |
| Previous Run : 33415                                  | Material : N/A                        |
| Written By : <i>[Signature]</i> 07-08-03              | Due Date : 8/10/2007 Qty: 60 Um: Each |
| Checked & Approved By : <i>[Signature]</i>            |                                       |
| Comment : Est Rev:A Removed from 9 Digit 05-12-02 JLM |                                       |

## Additional Product

Job Number:



|         |                       |               |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

|     |                |                          |
|-----|----------------|--------------------------|
| 1.0 | M304TR0675W091 | 304 RD Tube .675 x .091W |
|-----|----------------|--------------------------|



Comment: Qty.: 0.2078 f(s)/Unit Total : 12.4677 f(s)  
 Material: T304/T316 3/8 Schedule 40, Seamless, Ø0.675" OD, 0.091" wall thickness  
 (M304TR0.675W.091)  
 Batch *M10522#3* *SB/RP 07/08/03*

|     |          |                          |
|-----|----------|--------------------------|
| 2.0 | HARDINGE | HARDINGE CNC LATHE SMALL |
|-----|----------|--------------------------|



Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Dwg D2282 and Folio FA188

2-Deburr

*DTP 07/08/04 (81)*

|     |     |  |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|


*DTP 07/08/04 (81)*

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

|     |     |              |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|


*(116)*

Comment: SECOND CHECK

*mk 07/08/04*

|     |             |                       |
|-----|-------------|-----------------------|
| 5.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

 Identify and Stock  
 Location: *LF*
*[Signature] 07-08-06 (116)*

Date: Friday, 8/3/2007 9:25:53 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 33829

Part Number: D22823

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



116

Comment: FINAL INSPECTION/W/O RELEASE

207/08/08

Job Completion

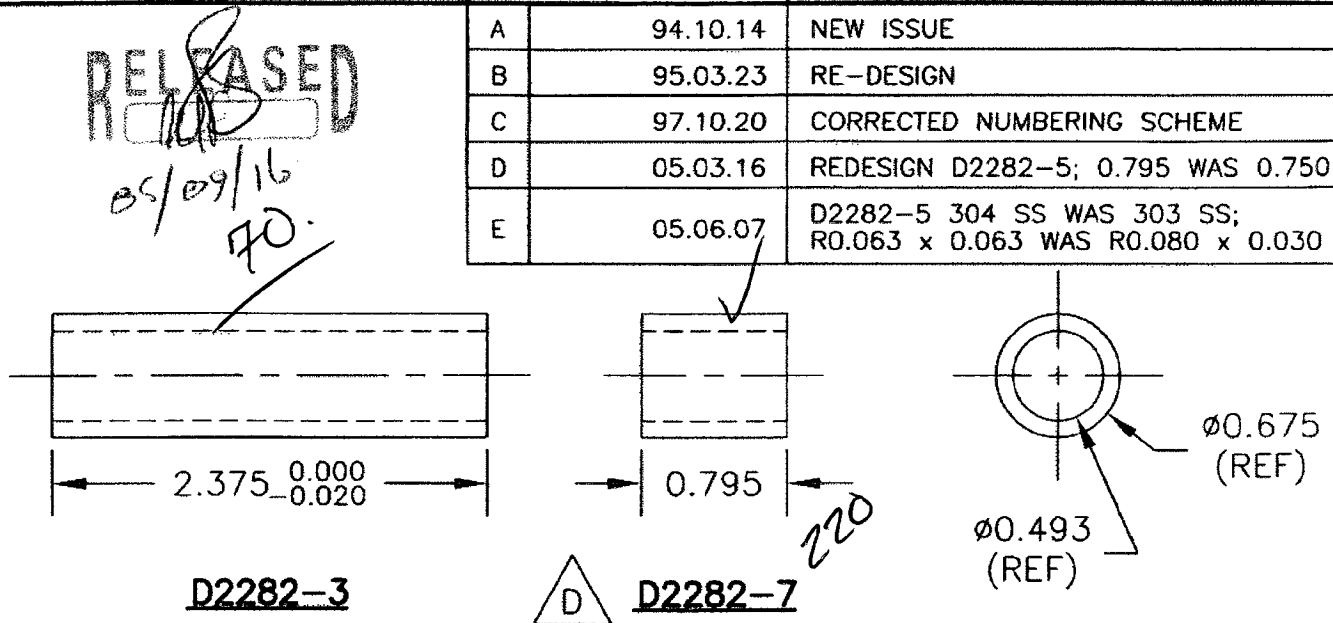


207/08/08



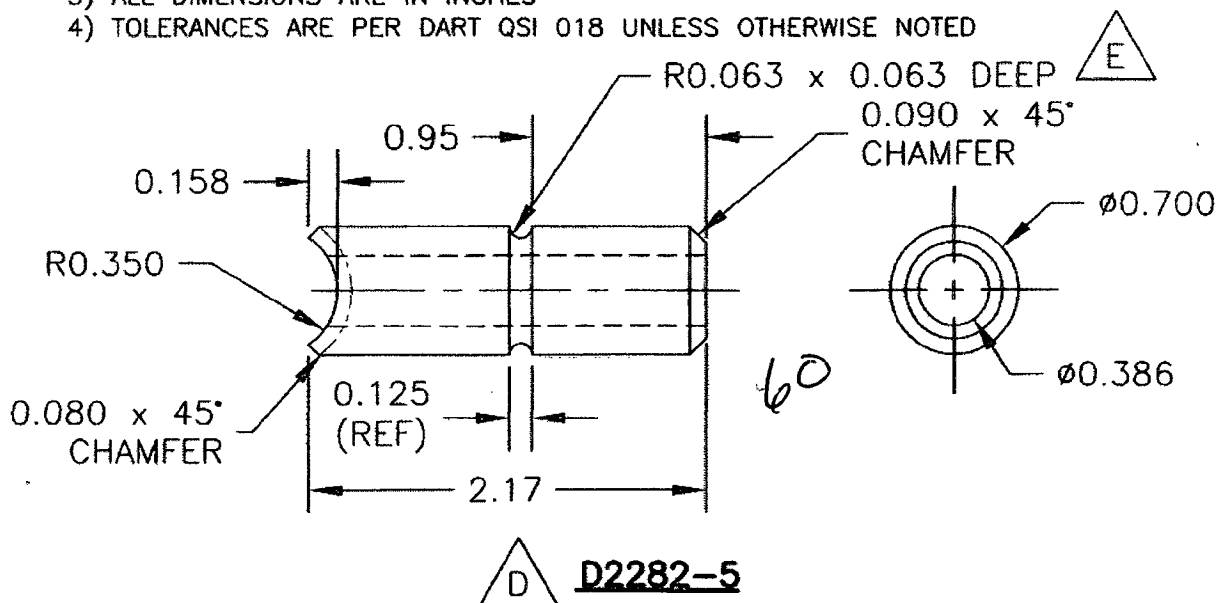


|                      |                                |   |                        |
|----------------------|--------------------------------|---|------------------------|
| DESIGN<br>BW         | DRAWN BY<br><i>[Signature]</i> | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA               |                        |
| CHECKED<br><i>4P</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D2282  | REV. E<br>SHEET 1 OF 2 |
| DATE<br>05.06.07     | TITLE<br>HANDLE TUBES          |   | SCALE<br>1:1           |
| A                    | 94.10.14                       | NEW ISSUE   |                        |
| B                    | 95.03.23                       | RE-DESIGN   |                        |
| C                    | 97.10.20                       | CORRECTED NUMBERING SCHEME                                      |                        |
| D                    | 05.03.16                       | REDESIGN D2282-5; 0.795 WAS 0.750                               |                        |
| E                    | 05.06.07                       | D2282-5 304 SS WAS 303 SS;<br>R0.063 x 0.063 WAS R0.080 x 0.030 |                        |



D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2282-5 STEM:

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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